

ENGINEERING CHANGE NOTICE NO. 04489					SHEET 1 OF 1	
DWG NO. 644.4100		REV: F	PREPARED BY: J. BECKER	DATE: 04/08/14		EFFECT ON DWG <input type="checkbox"/> INC. <input checked="" type="checkbox"/> UNINC.
DWG TITLE: PIVOT STEP ASSY						
APPROVED BY:	ENGR: <i>[Signature]</i>	MFG: <i>Dart Barber</i>	QC: <i>[Signature]</i>	EFF: NEXT ORDER		
TRANSACTION CODES (TC): A-ADD C-CREATE R-REVISE D-DELETE		REASON: UPDATE NOTE 4, FINISH SPECIFICATION.				

NOTES:

1. IDENTIFY ALL PARTS IN ACCORDANCE WITH MPP-120
2. MATERIAL: 2024-T3 ALUMINUM
3. MATERIAL: 6061-T6 ALUMINUM
4. FINISH IAW MPP-172 SECTION 2.1, SECTION 3.1, SECTION 4.1, SECTION 5.2.
5. MATERIAL: MDS-FILLED NYLON 6/6 SHEET, CUT OD CIRCLE USING 2" GASKET PUNCH,  
CUT ID HOLE USING 1/4" GASKET PUNCH
6. MATERIAL: MDS-FILLED NYLON 6/6 SHEET, CUT OD CIRCLE USING 2" GASKET PUNCH,  
CUT ID HOLE USING 5/16" GASKET PUNCH
7. DIMENSION VALUE HAS FINISH COATING OF 6-10 MIL (.006-.010) TAKEN INTO  
CONSIDERATION
8. ADD ADDITIONAL WASHER UNDERNEATH CASTLE NUTS IF NECESSARY.
9. FINISH: HARD ANODIZE IAW MIL-A-8625 TYPE III CLASS 2, COLOR BLACK.

**SHEET 1, NOTES IS:**

DOCUMENTS EFFECTED:

MDL  INSTALL INSTRUC  ICA  BOM  CHANGE CATEGORY  
 MAJOR  MINOR  DER REVIEW REQUIRED  
 YES  NO

APICAL  
INDUSTRIES, INC.

ENGINEERING CHANGE NOTICE NO.

04286

SHEET 1 OF 1

DWG NO. 644.4100

REV: F

PREPARED  
BY J. SOTO

DATE: 12/04/2013

EFFECT ON DWG  
 INC.  UNINC.

DWG TITLE: PIVOT STEP ASSY

APPROVED BY: ENGR *Primo*

MFG *David Barker*

QC

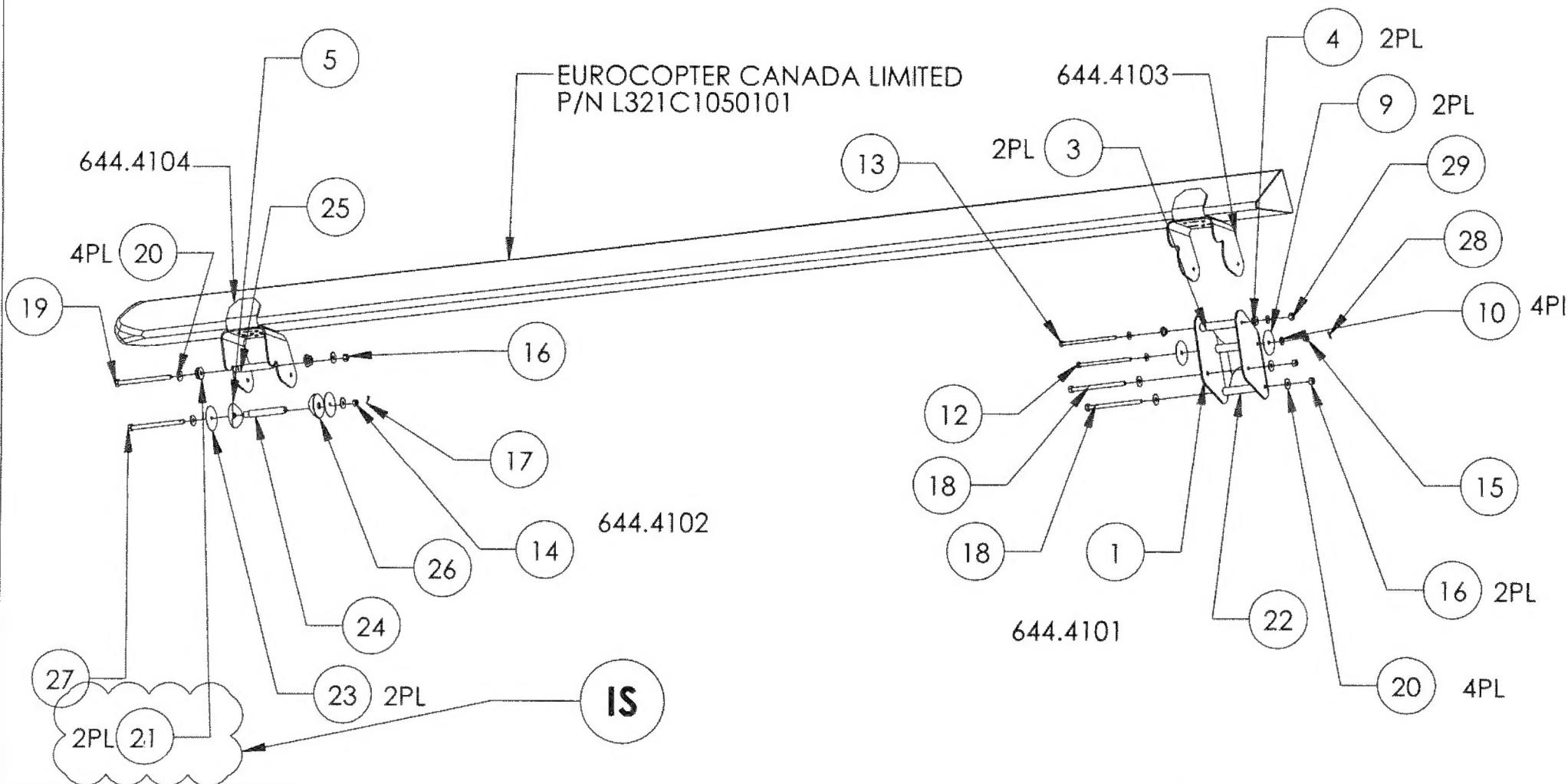
EFF. NEXT ORDER  
*EO*

TRANSACTION CODES (TC):  
A-ADD  
R-REVISE  
C-CREATE  
D-DELETE

REASON: REVISED F/N CALL OUT FROM 22 TO 21

ECR: 13-151

SHEET 1, ZONE D1 IS:



DOCUMENTS EFFECTED:

MDL  INSTALL INSTRUCTIONS  ICA  FMS  BOM

CHANGE CATEGORY

MAJOR  MINOR

DER REVIEW REQUIRED

YES  NO

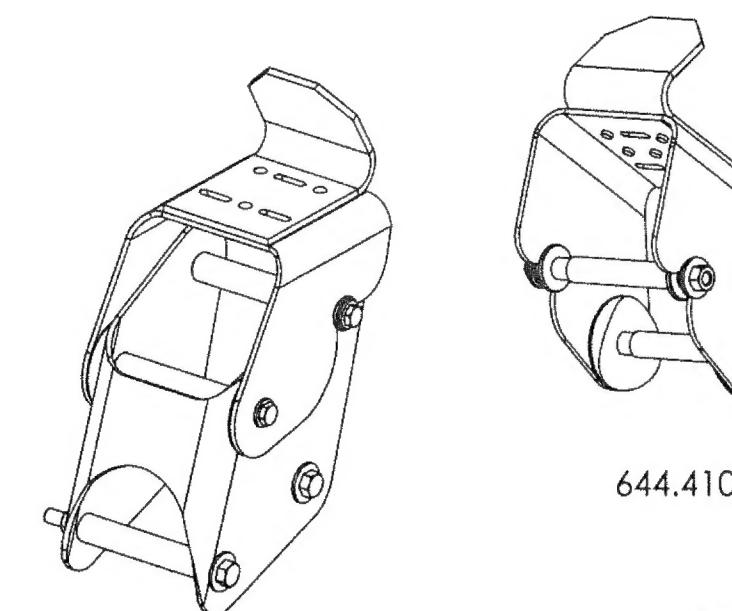
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NOTES:

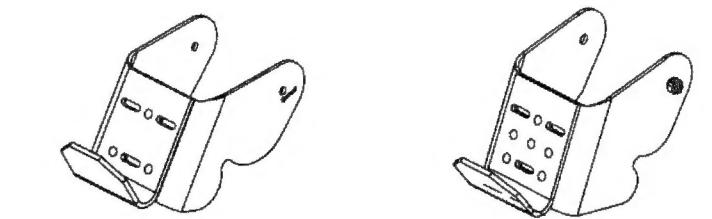
1. IDENTIFY ALL PARTS IN ACCORDANCE WITH MPP-120
2. MATERIAL: 2024-T3 ALUMINUM
3. MATERIAL: 6061-T6 ALUMINUM
4. FINISH: HARD ANODIZE IAW MIL-A-8625 TYPE III CLASS 2, COLOR BLACK; PRETREAT PR-148 ADHESION PROMOTER, PRIME WITH DESOTO 515X349 IAW BMS 10-79 TYPE III CLASS A GRADE A, POLYURETHANE PAINT CARDINAL 6409-RD03-S WITH CATALYST 340HP.
5. MATERIAL: MDS-FILLED NYLON 6/6 SHEET, CUT OD CIRCLE USING 2" GASKET PUNCH, CUT ID HOLE USING 1/4" GASKET PUNCH
6. MATERIAL: MDS-FILLED NYLON 6/6 SHEET, CUT OD CIRCLE USING 2" GASKET PUNCH, CUT ID HOLE USING 5/16" GASKET PUNCH
7. DIMENSION VALUE HAS FINISH COATING OF 6-10 MIL (.006-.010) TAKEN INTO CONSIDERATION

8. ADD ADDITIONAL WASHER UNDERNEATH CASTLE NUTS IF NECESSARY.

9. FINISH: HARD ANODIZE IAW MIL-A-8625 TYPE III CLASS 2, COLOR BLACK.



REVISIONS			
REV.	DESCRIPTION	DATE	APPROVED
A	INCORPORATED ECN 01310, 01322, 01332, & 01357.	11-22-05	S. JOSEPH
B	INCORPORATED ECN 01370, 01418, 01796, & 01838.	05-21-07	P. BRAVO
C	INCORPORATED ECN 01908, 02326, 03022	12-14-10	P. BRAVO
D	INCORPORATED ECN 03111, 03113, 03208, & 03740.	12-10-12	P. BRAVO
E	INCORPORATED ECN 03941	06-19-13	P. BRAVO
F	INCORPORATED ECN 04006	7-29-13	P. BRAVO



644.4103

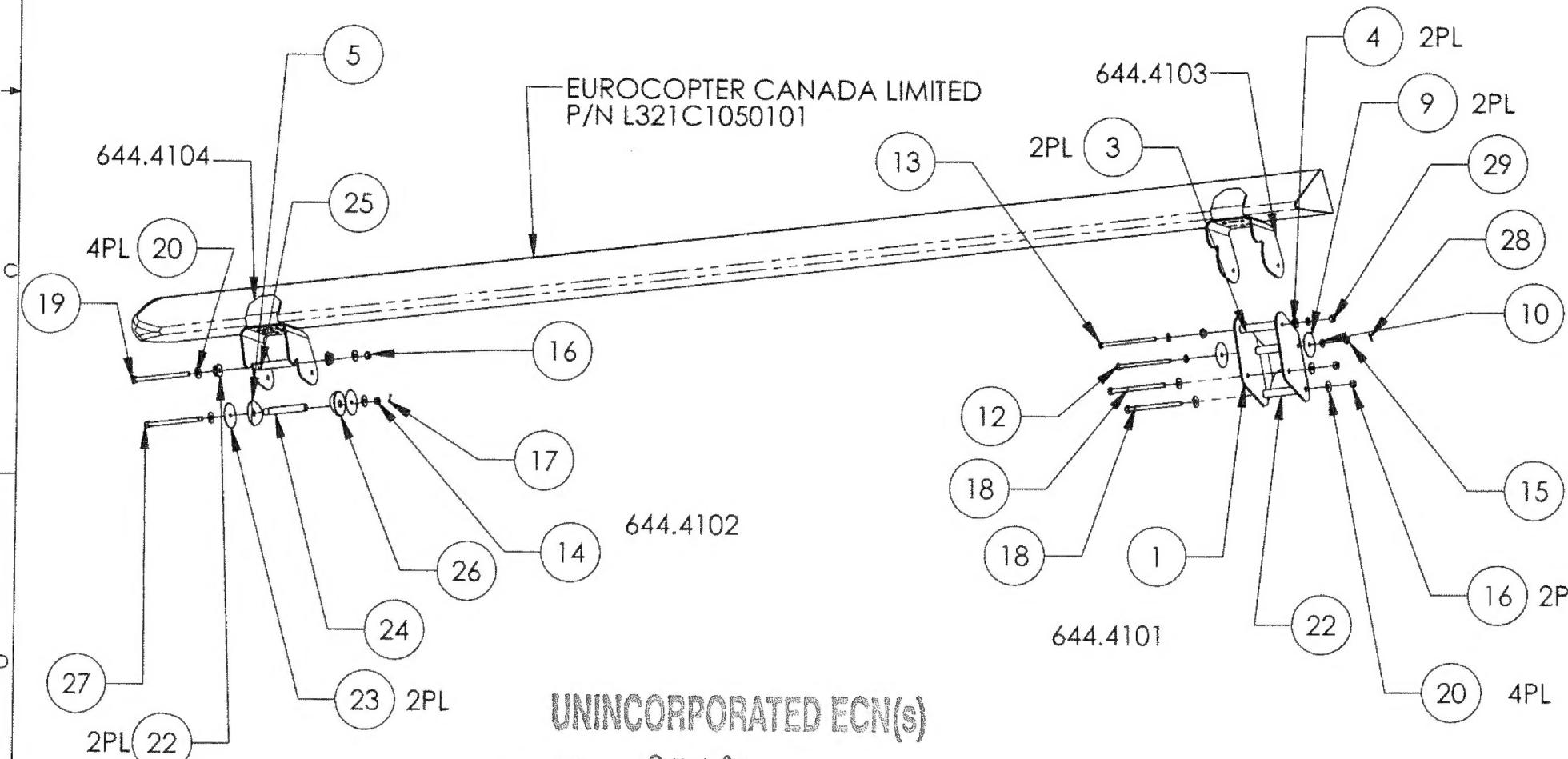
644.4104

	1	29	601.3273	LOCKNUT FULL	MS2104N4
	1	28	601.2640	COTTER PIN	MS24665-132
	1	27	601.2328	BOLT, HEX	AN5-45
	1	26	644.4124	WASHER, PIVOT	3/6
	1	25	644.4123	FWD CROSSTUBE BUSHING	3/9
	1	24	644.4122	FWD CROSSTUBE BUSHING	3/9
	2	23	644.4121	WASHER, NYLON	6
	1	22	644.4120	SPACER, CROSS-TUBE	3/4
	2	21	644.4119	SPACER, FWD STOP	3/4
	4	4	20	601.2110	WASHER, FLAT THICK
	1	19	601.2250	BOLT, HEX	AN5-50
	2	18	601.2249	BOLT, HEX	AN5-43A
	1	17	601.3315	COTTER PIN	MS24665-210
	1	16	601.3272	LOCKNUT FULL	MS2104N5
	1	15	601.1435	NUT, HEX CASTLE FULL	AN310-4
	1	14	601.3270	NUT, HEX CASTLE FULL	AN310-5
	1	13	601.3407	BOLT, HEX	AN4-47A
	1	12	601.2434	BOLT, HEX	AN4-45
6	3	11	601.2326	RIVET, COUNTERSUNK	MS20426AD5-B
	4	10	601.0863	WASHER, THICK	NAS1149C 0463R
	2	9	644.4118	WASHER, NYLON	5
	1	8	644.4117	BRACKET, FWD PIVOT	2/4
	1	7	644.4116	BRACKET (SMALL), FWD	2/4
	1	6	644.4115	BRACKET (SMALL), AFT	2/4
	1	5	644.4114	WASHER, PIVOT	3/4
	2	4	644.4113	SPACER, STOP	3/4
	2	3	644.4112	SPACER	3/4
	1	2	644.4111	BRACKET, AFT PIVOT	2/4
	1	1	644.4110	BRACKET (LARGE), AFT	2/4
			644.4104	FWD BRACKET ASSY	
			644.4103	AFT BRACKET ASSY	
			644.4102	PIVOT STEP ASSY	
			644.4101	PIVOT STEP ASSY	

4104	4103	4102	4101	FIND #	PART #	DESCRIPTION	MAT'L	SPEC.
				QTY	PARTS LIST			
					ORIGINAL DATE (MO-DA-YR)	08-01-05		
					DRAWN BY	S. JOSEPH		
					DRAWING APPROVAL	S. JOSEPH 08-29-05		
					CONTRACT NO.			
					UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN INCHES TOLERANCES ARE: 2 PLACE DECIMALS $\pm .03$ 3 PLACE DECIMALS $\pm .010$ ANGLES $\pm .5^\circ$			
					SIZE	CAGE CODE	DWG. NO.	
					B	07M26	644.4100	REV. F
					SCALE	NONE		SHEET 1 OF 16

UNINCORPORATED ECN(s)

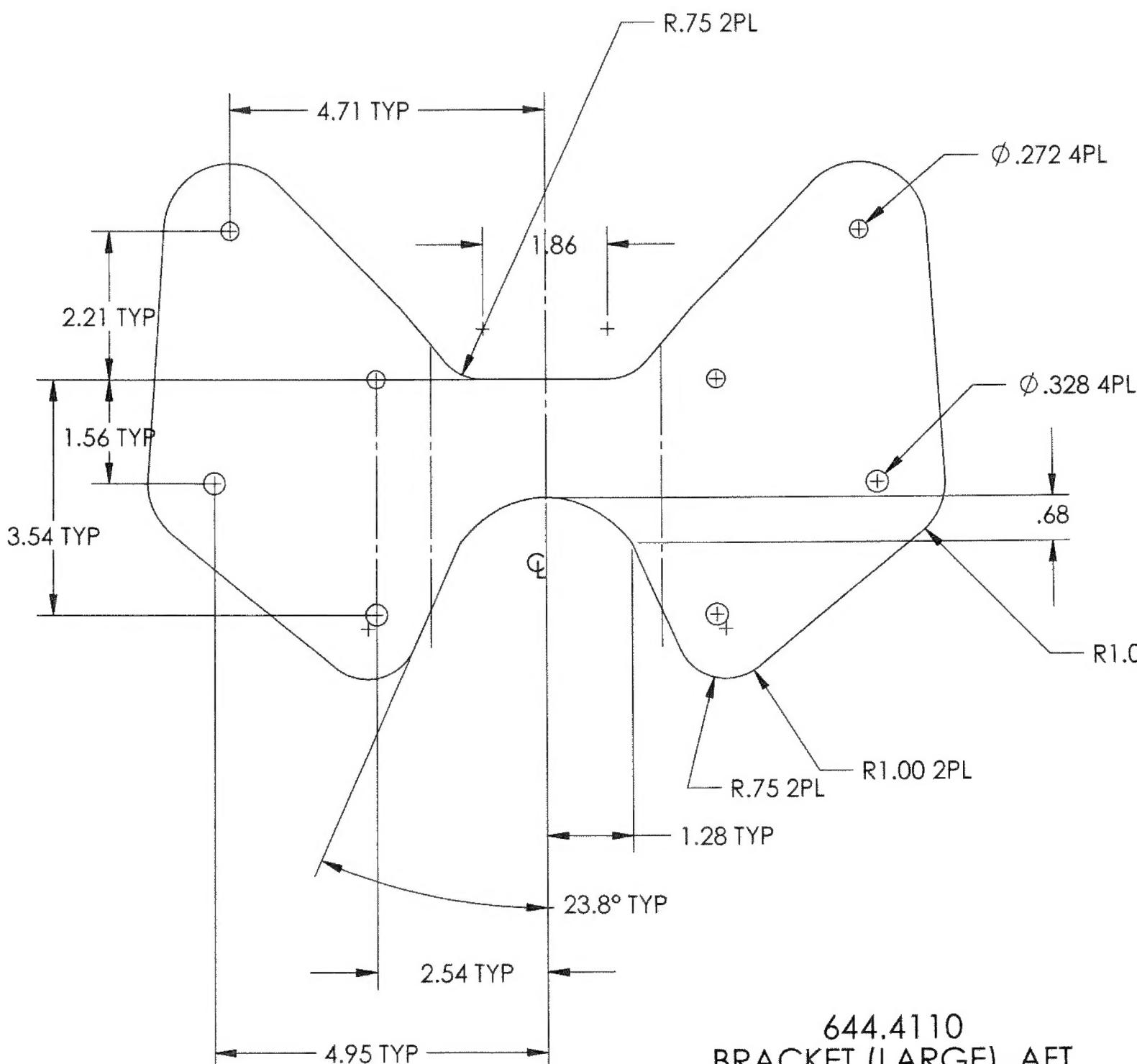
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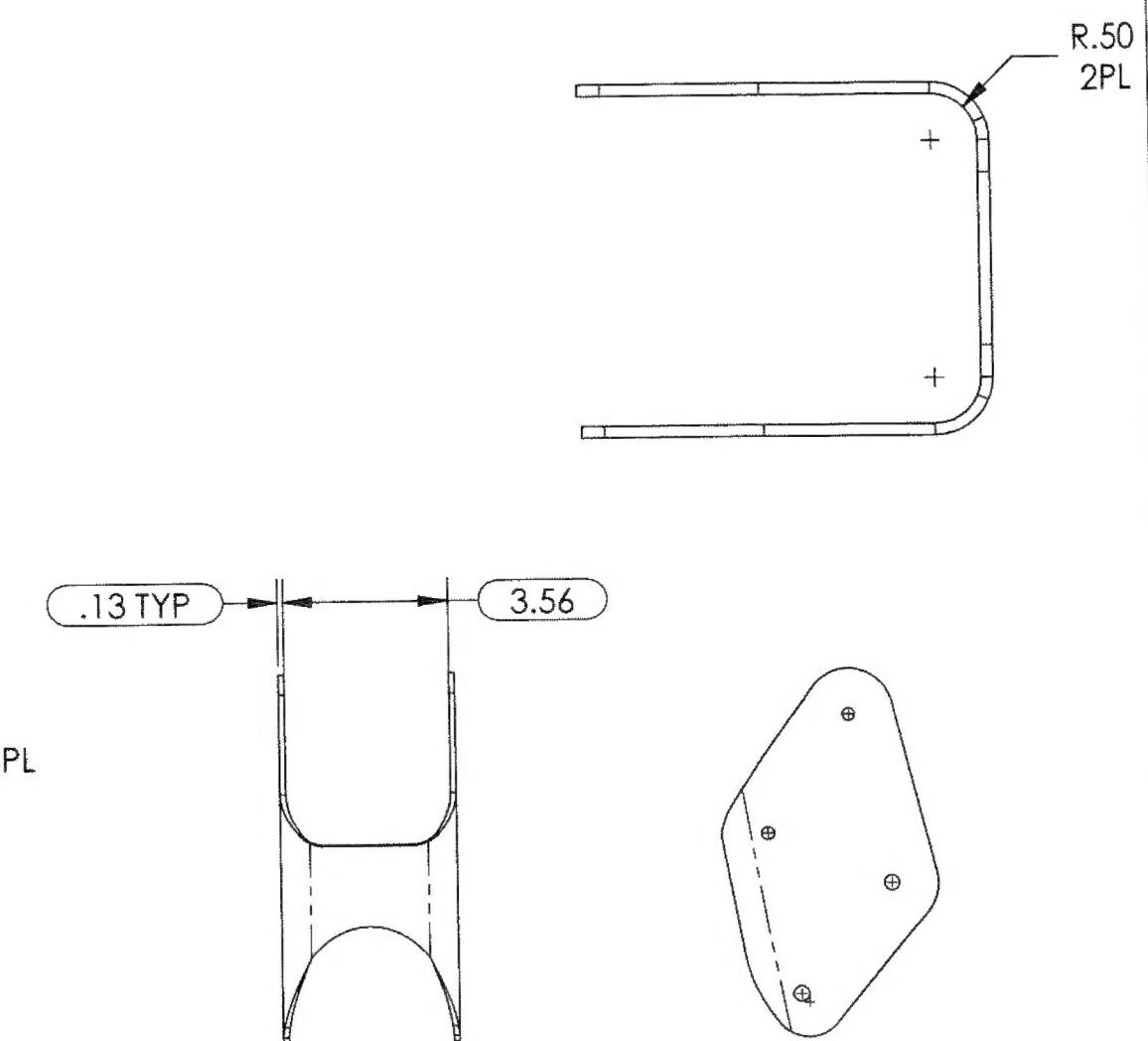
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644.4110  
BRACKET (LARGE), AFT



ORIGINAL DATE (MO-DA-YR)	08-01-05
DRAWN BY	ICHECKER
D.PARROTT	S.JOSEPH
DRAWING APPROVAL	
S.JOSEPH 08-29-05	
CONTRACT NO.	

UNLESS OTHERWISE SPECIFIED  
DIMENSIONS ARE IN INCHES  
TOLERANCES ARE:  
2 PLACE DECIMALS  $\pm .03$   
3 PLACE DECIMALS  $\pm .010$   
ANGLES  $\pm .5^\circ$

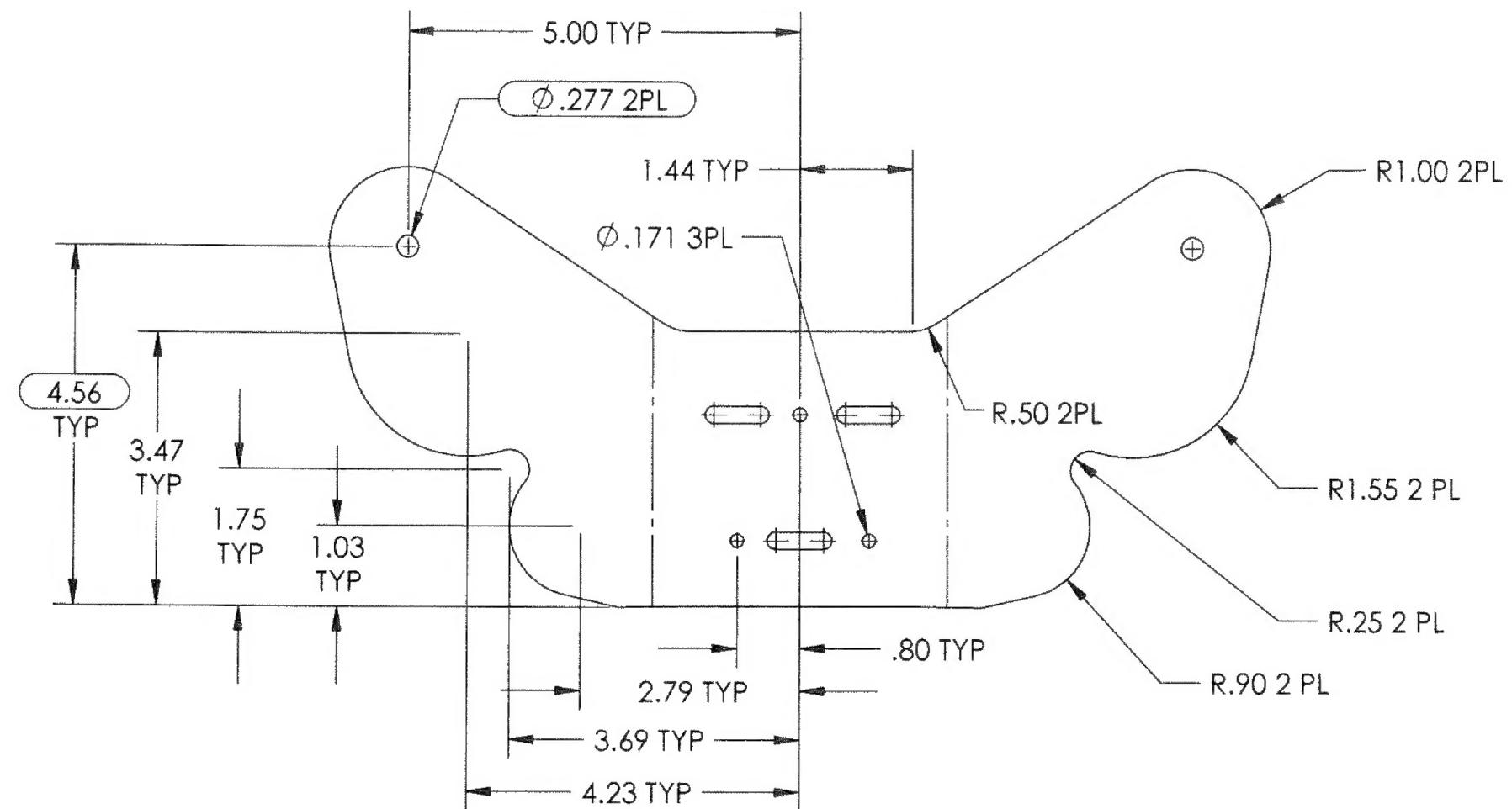
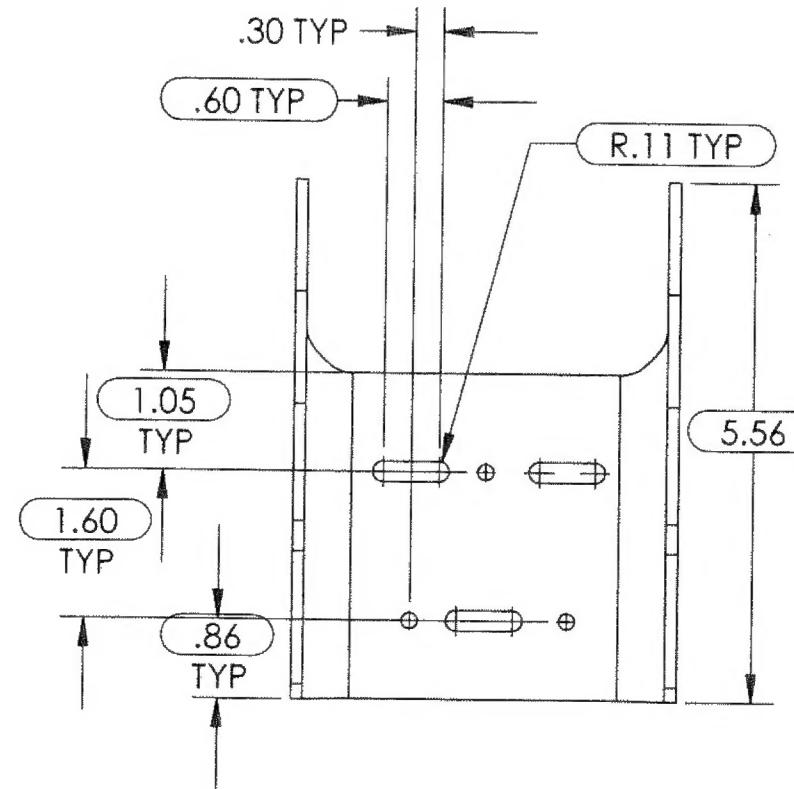
APICAL INDUSTRIES  
2608 TEMPLE HEIGHTS DR.  
OCEANSIDE, CA. 92056-3512 (760)724-5300

PIVOT STEP ASSY

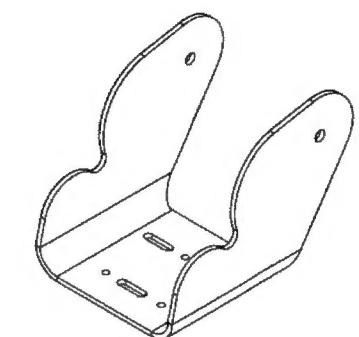
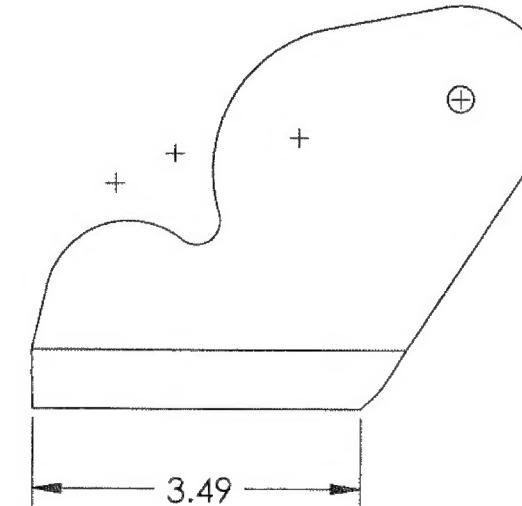
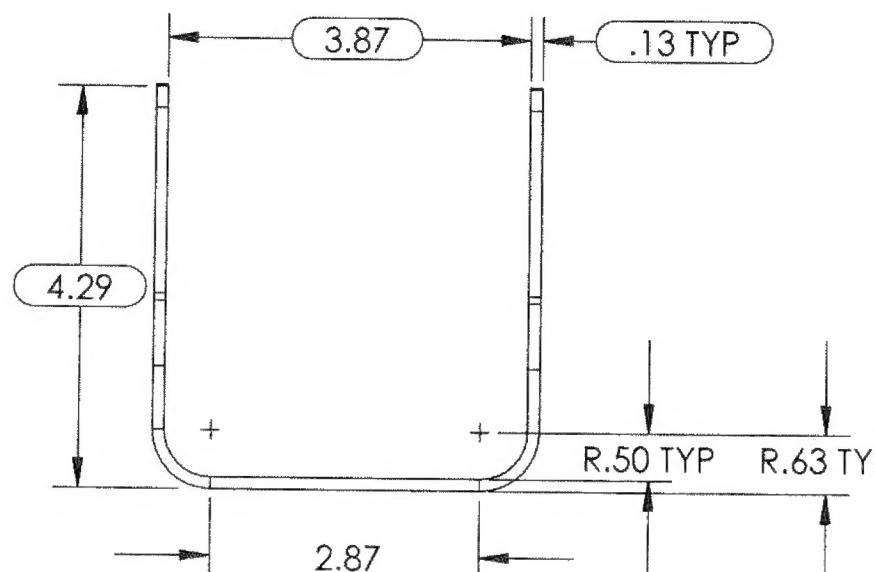
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SCALE NONE		SHEET 2 OF 16	

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A



C



644.4111  
BRACKET, AFT PIVOT

ORIGINAL DATE (MO-DA-YR)	08-01-05	DRAWN BY D.PARROTT	CHECKER S.JOSEPH
DRAWING APPROVAL	S.JOSEPH 08-27-05		
CONTRACT NO.			
UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN INCHES TOLERANCES ARE: 2 PLACE DECIMALS $\pm .03$ 3 PLACE DECIMALS $\pm .010$ ANGLES $\pm .5^\circ$	APICAL INDUSTRIES 2608 TEMPLE HEIGHTS DR. OCEANSIDE, CA. 92056-3512 (760)724-5300		
PIVOT STEP ASSY			
SIZE	CAGE CODE	DWG. NO.	644.4100
B	07MZ6	REV.	F
SCALE	NONE	SHEET	3 OF 16

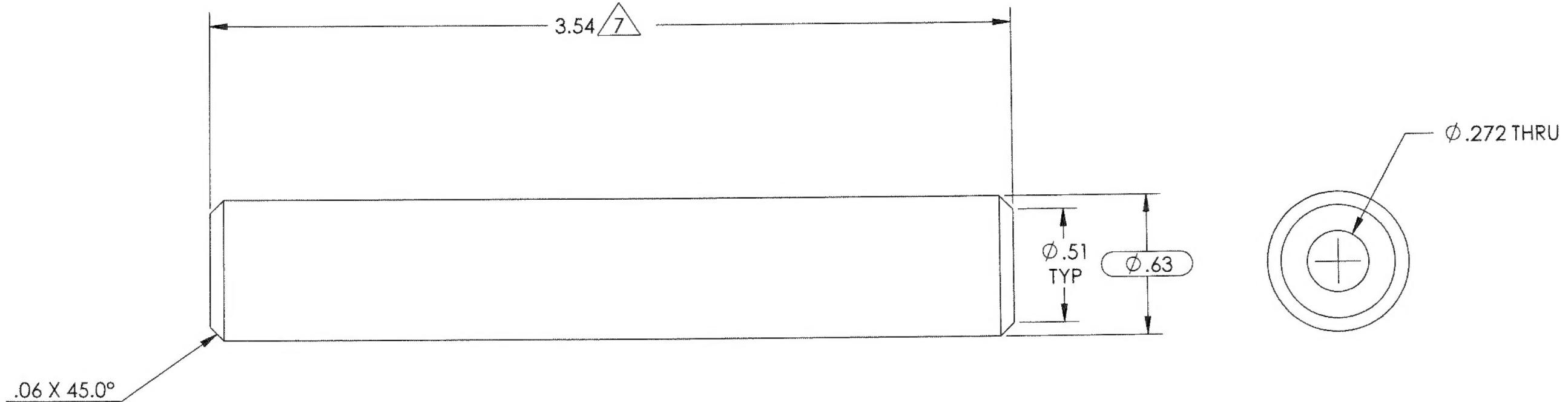
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D

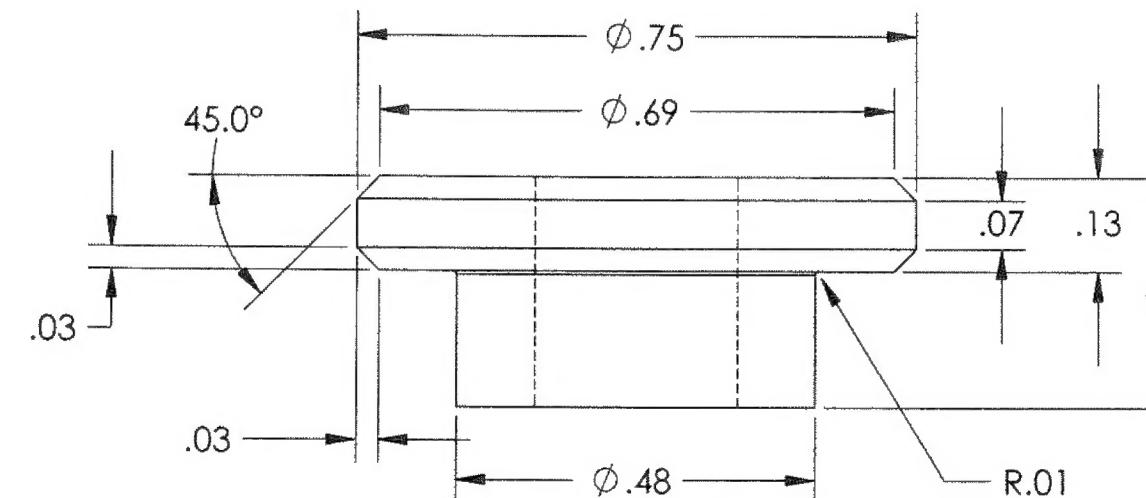


644.4112  
SPACER

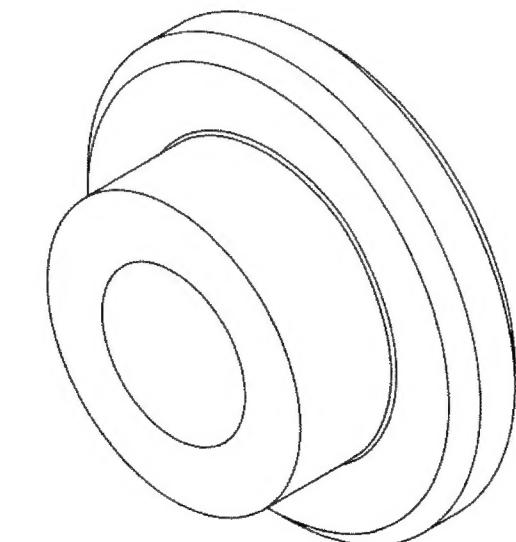
ORIGINAL DATE (MO-DA-YR)	08-01-05
DRAWN BY	CHECKER
D. PARROT	S. JOSEPH
DRAWING APPROVAL	
S. JOSEPH 08-29-05	
CONTRACT No.	
APICAL INDUSTRIES	
2608 TEMPLE HEIGHTS DR.	
OCEANSIDE, CA. 92056-3512	(760)724-5300
PIVOT STEP ASSY	
UNLESS OTHERWISE SPECIFIED	
DIMENSIONS ARE IN INCHES	
TOLERANCES ARE:	
2 PLACE DECIMALS $\pm .03$	
3 PLACE DECIMALS $\pm .010$	
ANGLES $\pm .5^\circ$	
SHEET	4 OF 16
SHEET	644.4100
SCALE	NONE
CAGE CODE	DWG. NO.
B 07MZ6	REV. F

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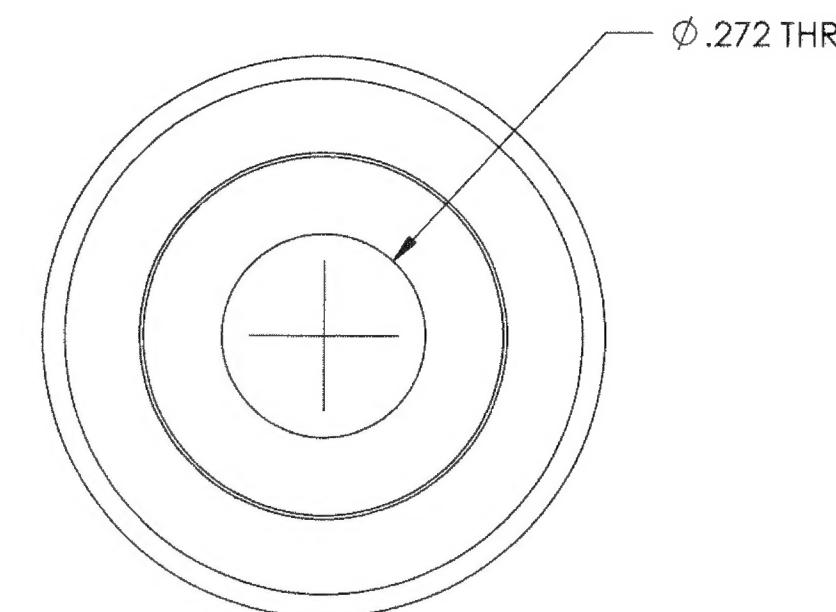
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C



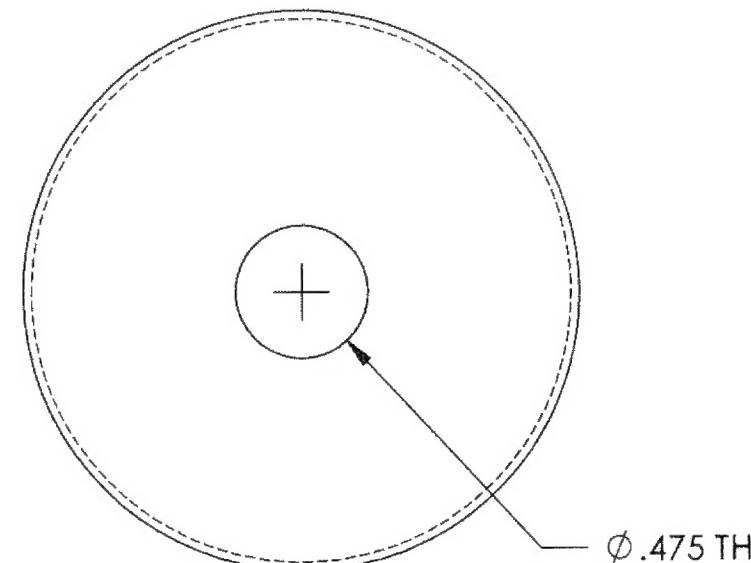
D

644.4113  
SPACER, STOP

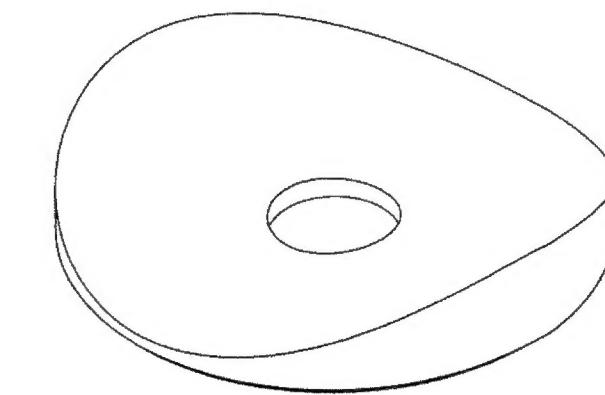
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DRAWN BY D.PARROTT	CHECKER S.JOSEPH
DRAWING APPROVAL S.JOSEPH 08-29-05	
CONTRACT No.	
UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN INCHES TOLERANCES ARE: 2 PLACE DECIMALS $\pm .03$ 3 PLACE DECIMALS $\pm .010$ ANGLES $\pm .5^\circ$	APICAL INDUSTRIES 2608 TEMPLE HEIGHTS DR. OCEANSIDE, CA. 92056-3512 (760)724-5300
SIZE B	CAGE CODE 07MZ6
DWG. NO. 644.4100	REV. F
SCALE NONE	SHEET 5 OF 16

1 2 3 4 5 6 7 8  
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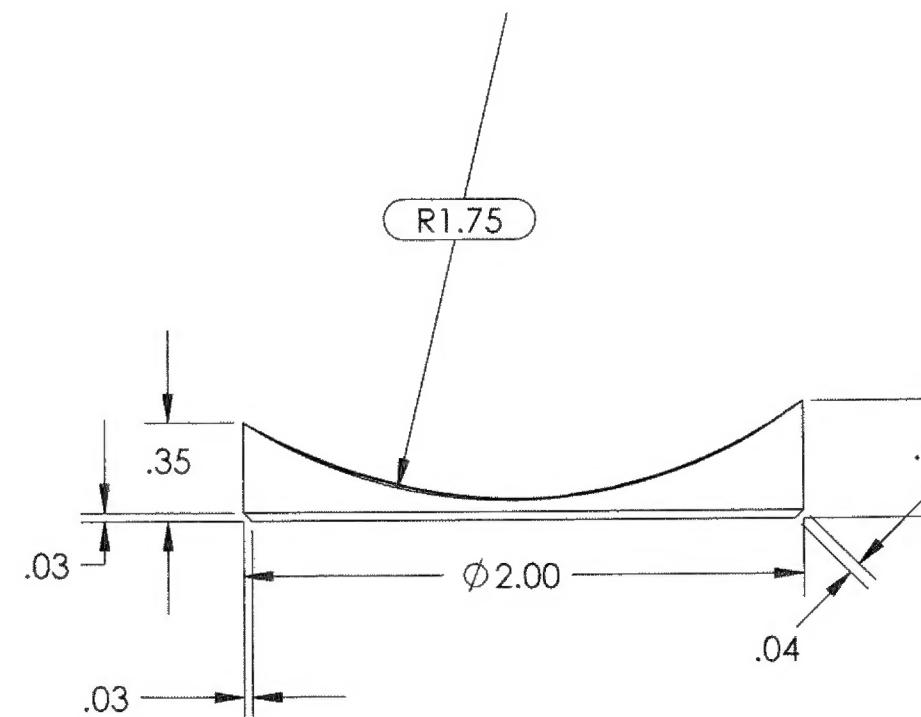
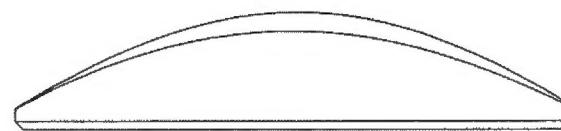
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B



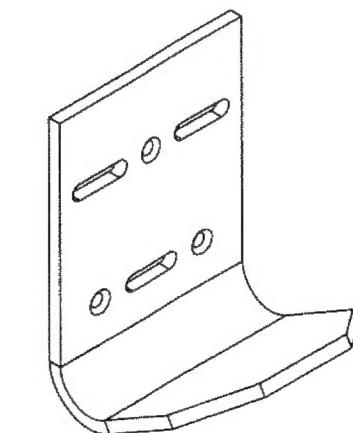
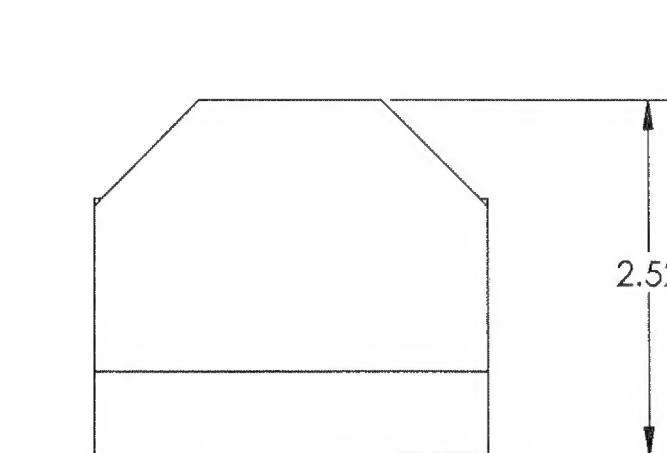
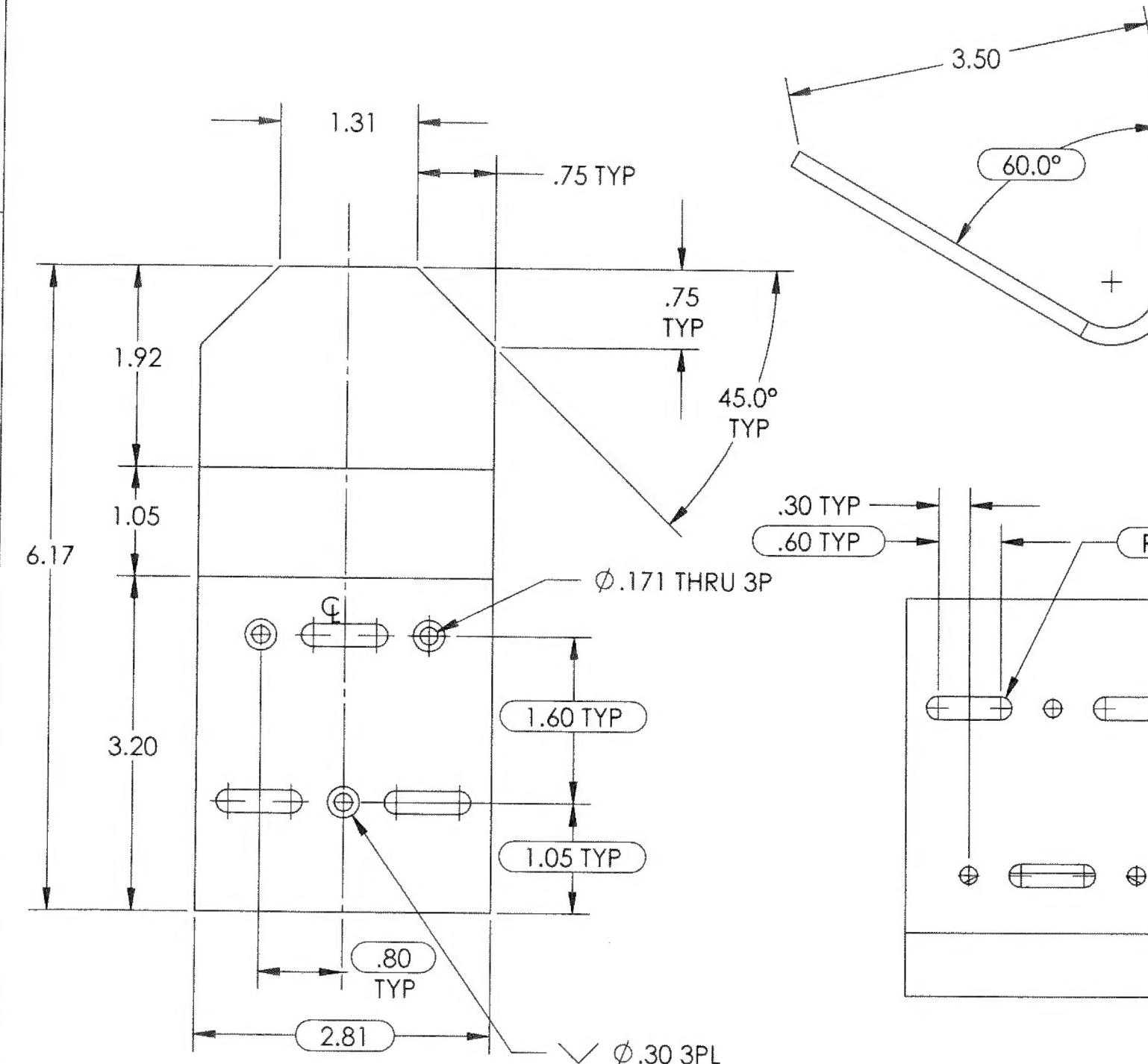
C



644.4114  
WASHER, PIVOT

ORIGINAL DATE 08-01-05 (MO-DA-YR)	CHECKER		
DRAWN BY D.PARROT	S.JOSEPH		
DRAWING APPROVAL	S.JOSEPH 08-29-05		
CONTRACT NO.			
UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN INCHES TOLERANCES ARE: 2 PLACE DECIMALS $\pm .03$ 3 PLACE DECIMALS $\pm .010$ ANGLES $\pm 5^\circ$			
SHEET 6 OF 16			
SIZE B	CAGE CODE 07MZ6	DWG. NO. 644.4100	REV. F

A



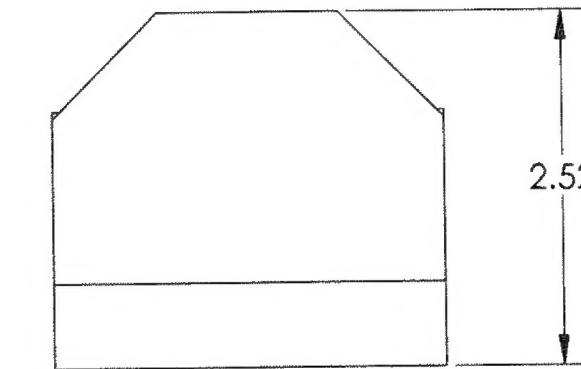
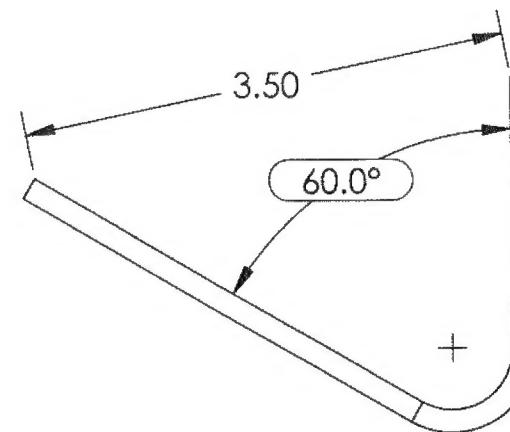
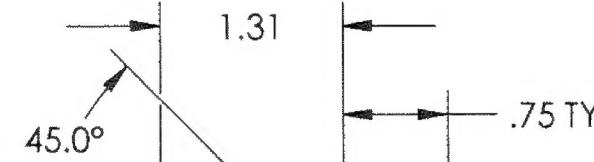
644.4115  
BRACKET (SMALL), AFT

FLAT VIEW

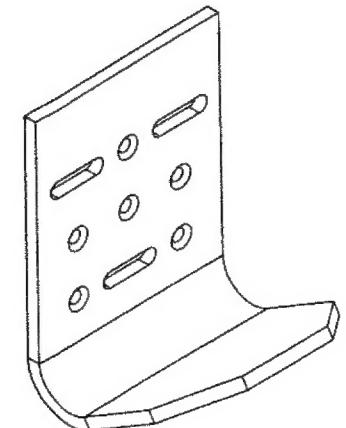
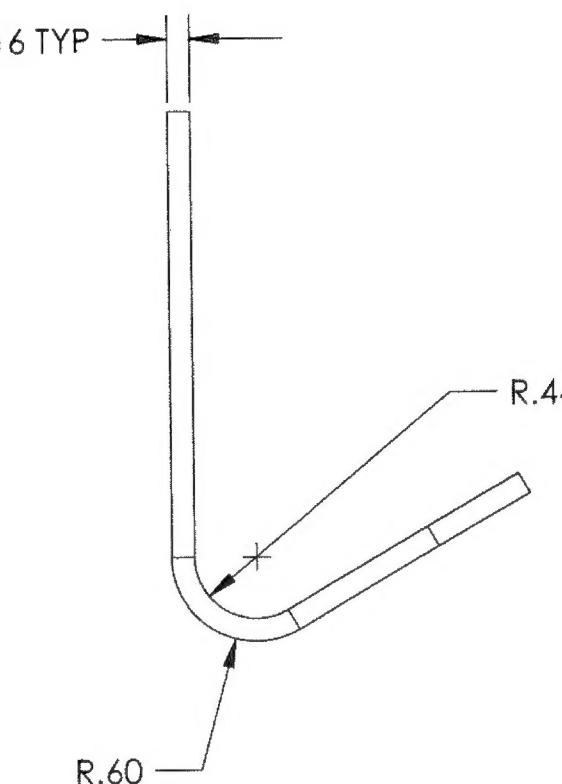
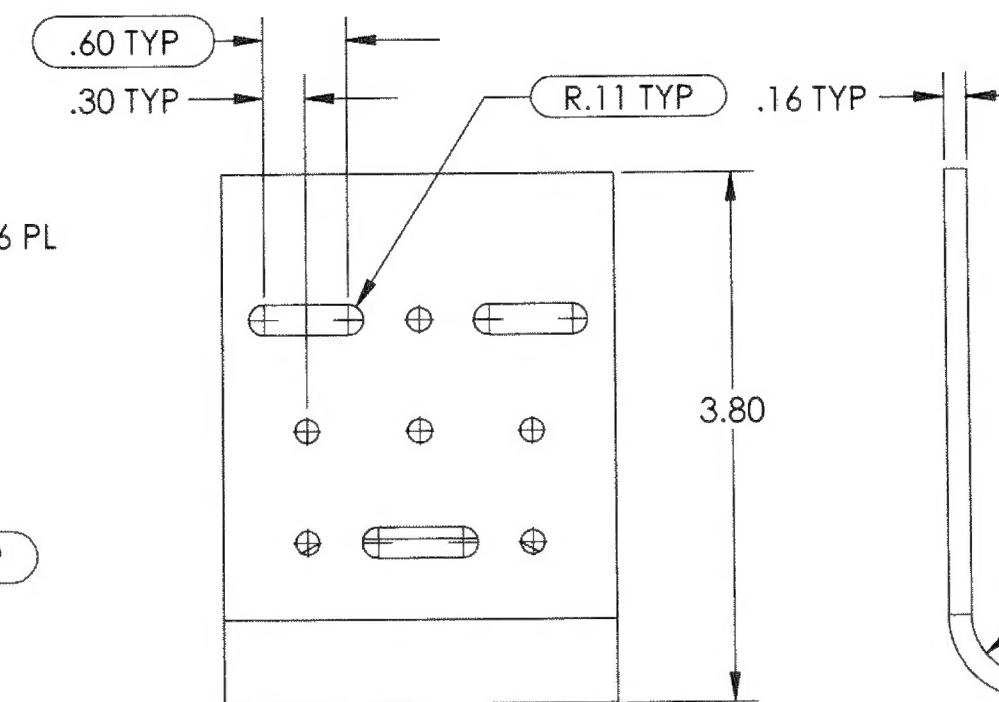
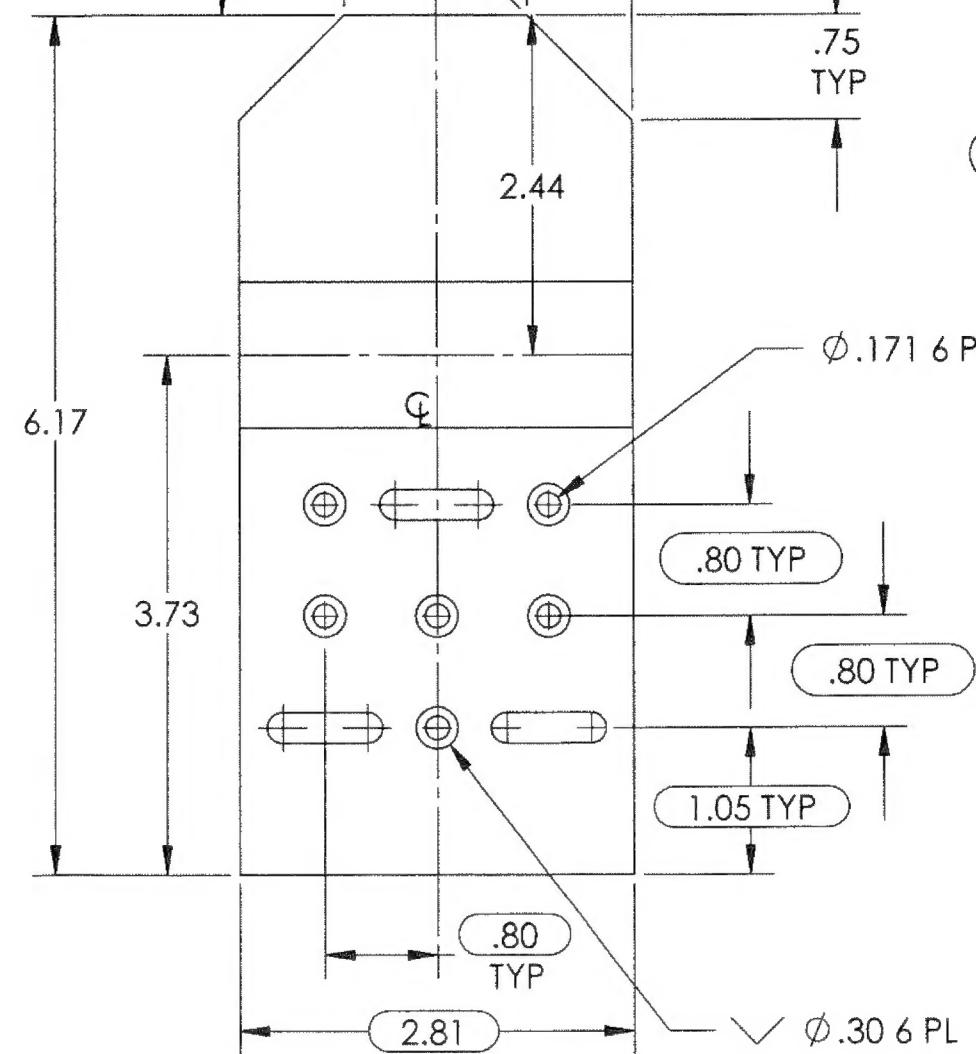
ORIGINAL DATE (MO-DA-YR)	08-01-05	APICAL INDUSTRIES
DRAWN BY	CHECKER	
D.PARROTT	S.JOSEPH	
DRAWING APPROVAL		
S.JOSEPH 08-29-05		
CONTRACT NO.		
UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN INCHES TOLERANCES ARE: 2 PLACE DECIMALS $\pm .03$ 3 PLACE DECIMALS $\pm .010$ ANGLES $\pm .5^\circ$		
SIZE	CAGE CODE	DWG. NO.
8	07MZ6	644.4100
REV.		F
SCALE	NONE	SHEET 7 OF 16

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B



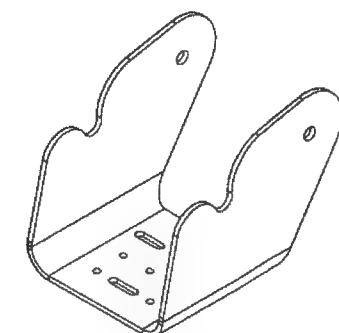
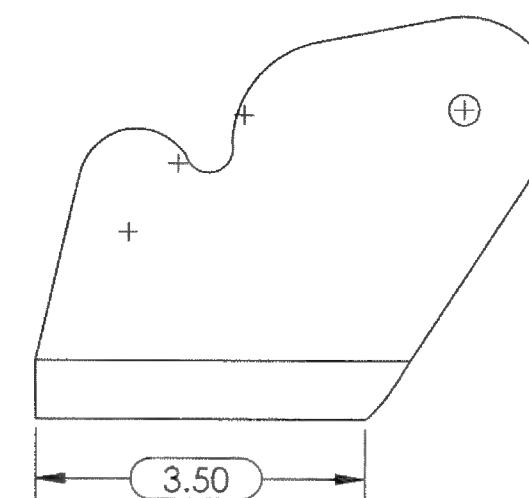
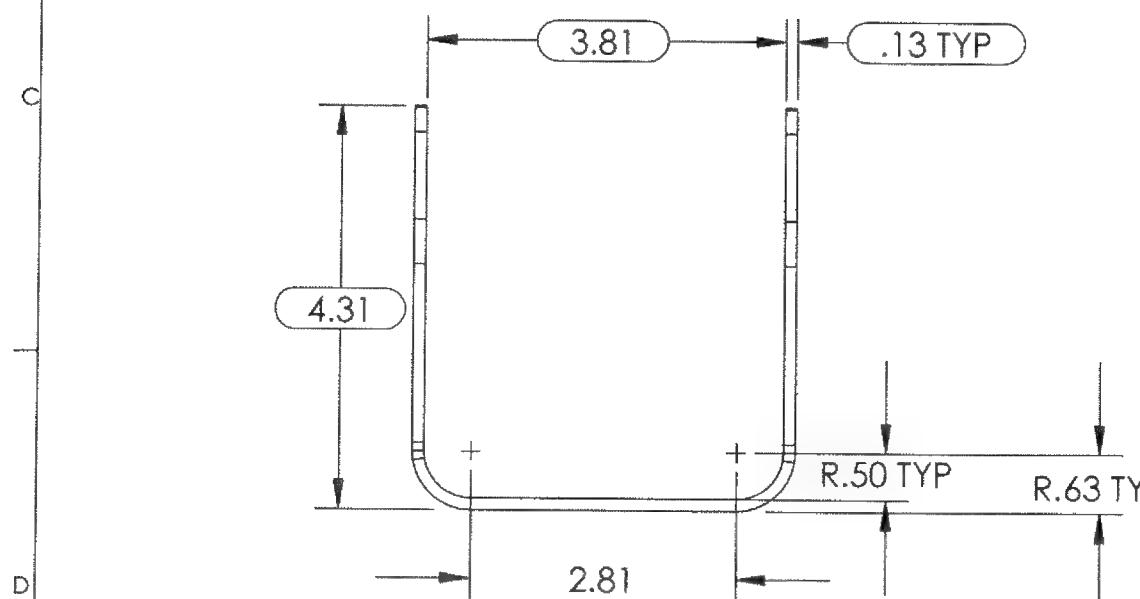
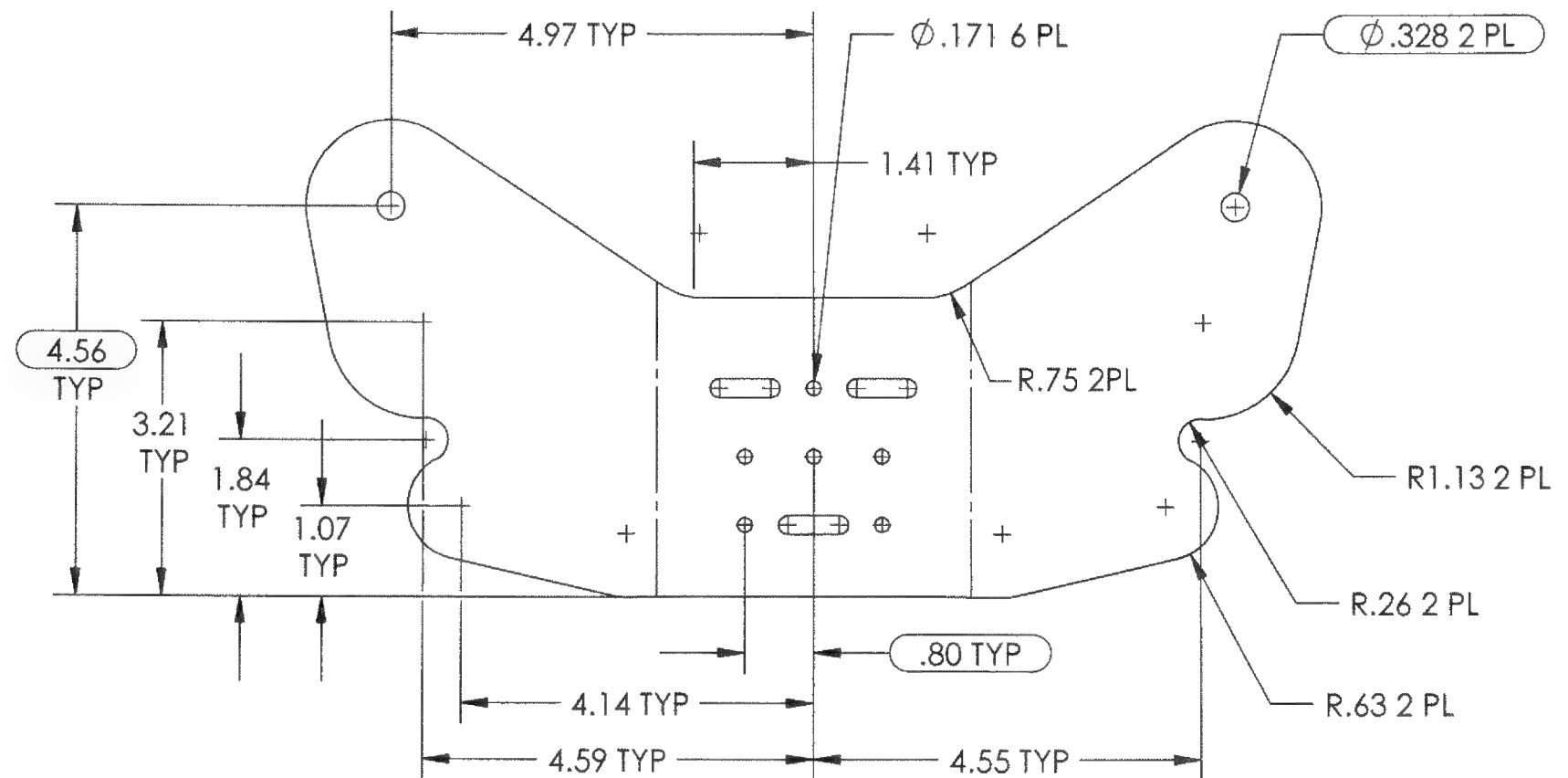
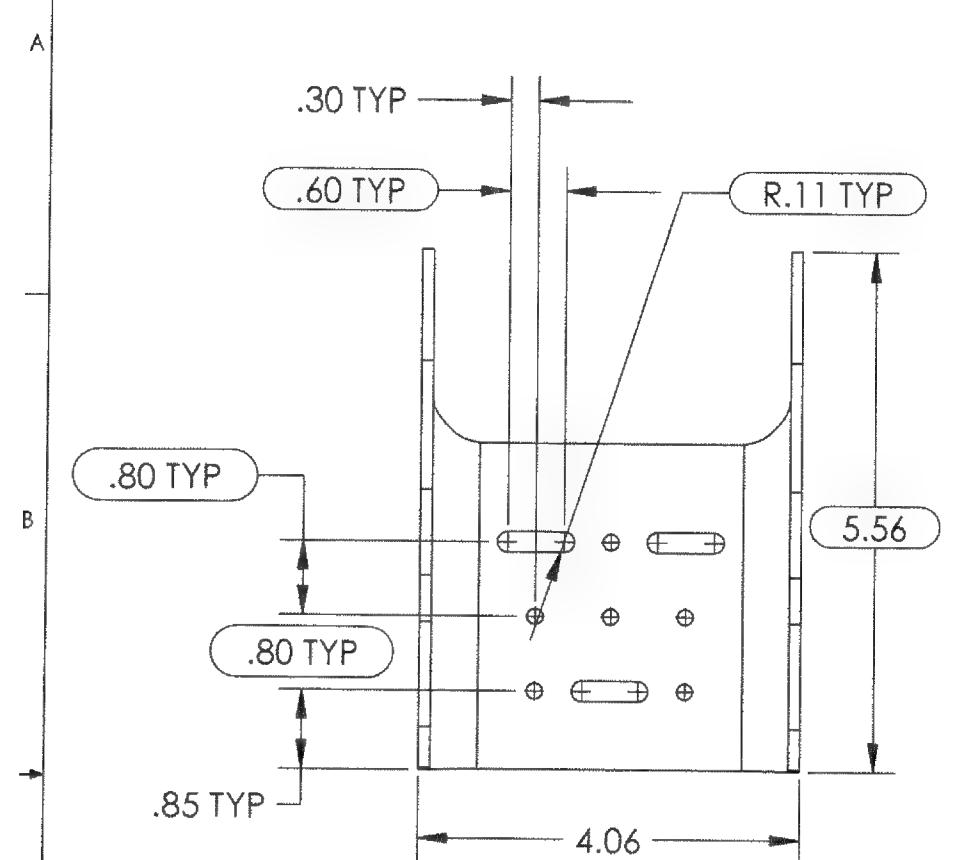
644.4116  
BRACKET (SMALL), FWD

ORIGINAL DATE (MO-DA-YR)	08-01-05
DRAWN BY	CHECKER
D.PARROT	S.JOSEPH
DRAWING APPROVAL	
S.JOSEPH	08-29-05
CONTRACT No.	

APICAL INDUSTRIES		
2608 TEMPLE HEIGHTS DR.		
OCEANSIDE, CA. 92056-3512 (760)724-5300		
PIVOT STEP ASSY		
SIZE	CAGE CODE	D/WG. NO.
B	07MZ6	644.4100
SCALE	NONE	REV. F
SHEET 8 OF 16		

UNLESS OTHERWISE SPECIFIED  
DIMENSIONS ARE IN INCHES  
TOLERANCES ARE:  
2 PLACE DECIMALS  $\pm .03$   
3 PLACE DECIMALS  $\pm .010$   
ANGLES  $\pm .5^\circ$

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644.4117  
BRACKET, FWD PIVOT

ORIGINAL DATE (MO-DA-YR)	08-01-05	APICAL INDUSTRIES
DRAWN BY	CHECKER	2608 TEMPLE HEIGHTS DR. OCEANSIDE, CA. 92056-3512 (760)724-5300
D.PARROTT	S.JOSEPH	
DRAWING APPROVAL	S.JOSEPH 08-29-05	
CONTRACT NO.		
UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN INCHES TOLERANCES ARE: 2 PLACE DECIMALS $\pm .03$ 3 PLACE DECIMALS $\pm .010$ ANGLES $\pm .5^\circ$		PIVOT STEP ASSY
SIZE	CAGE CODE	DWG. NO.
B	07M26	644.4100
SCALE	NONE	REV. F
		SHEET 9 OF 16

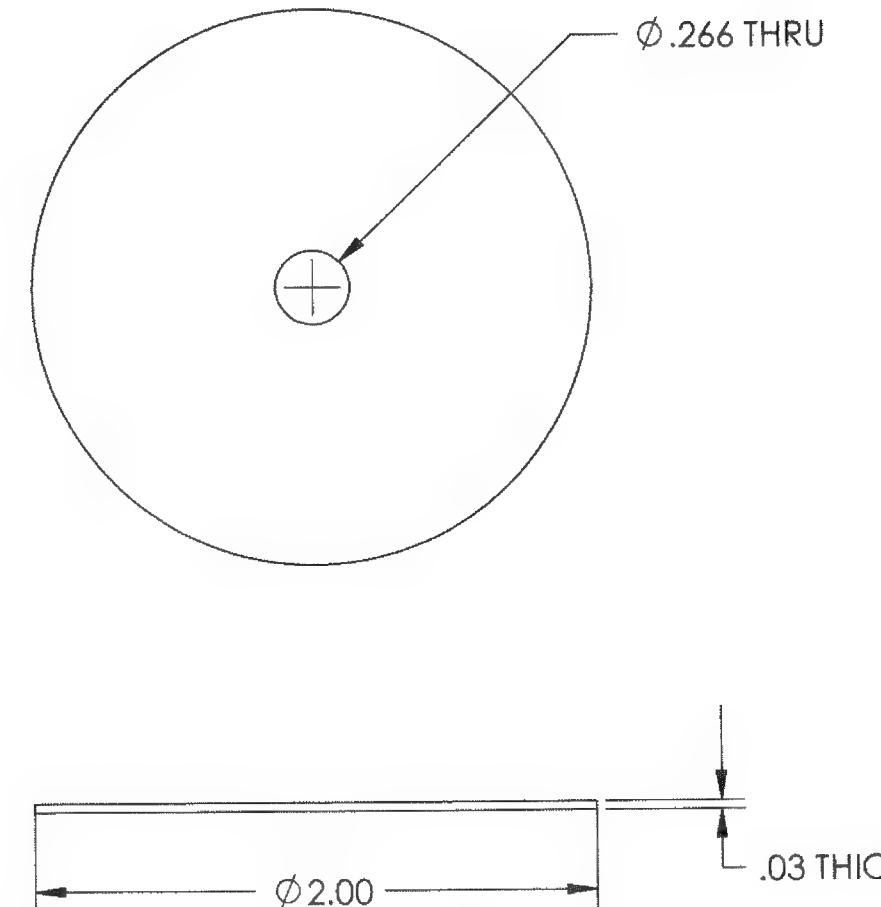
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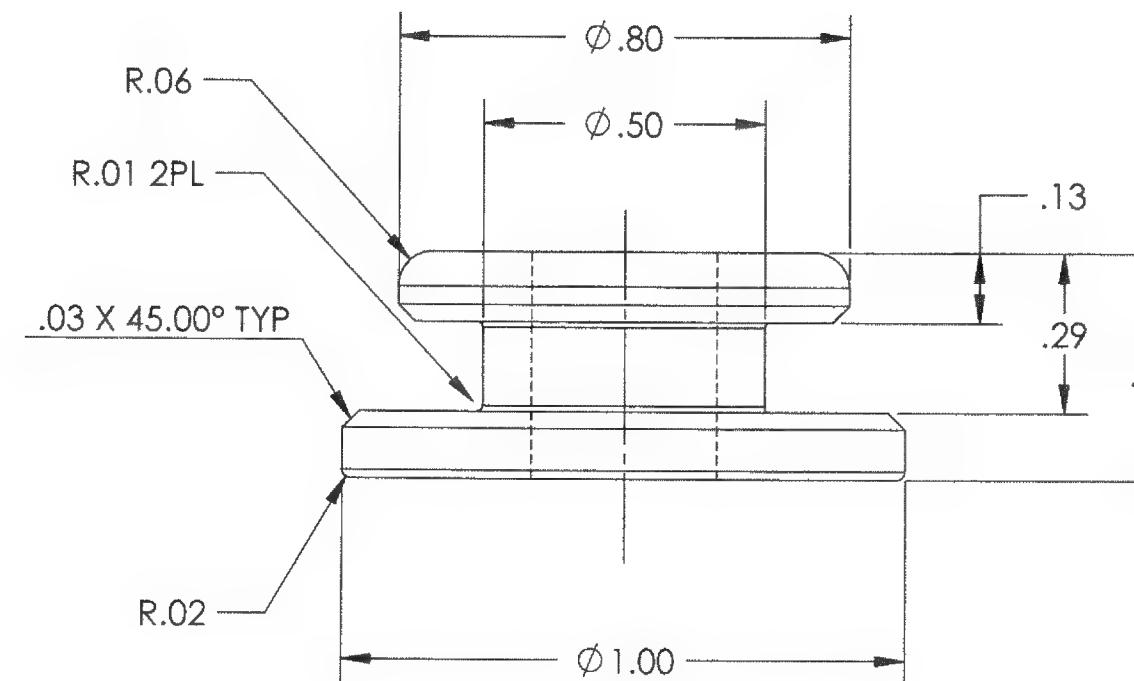
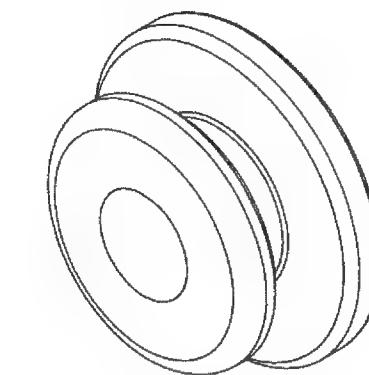
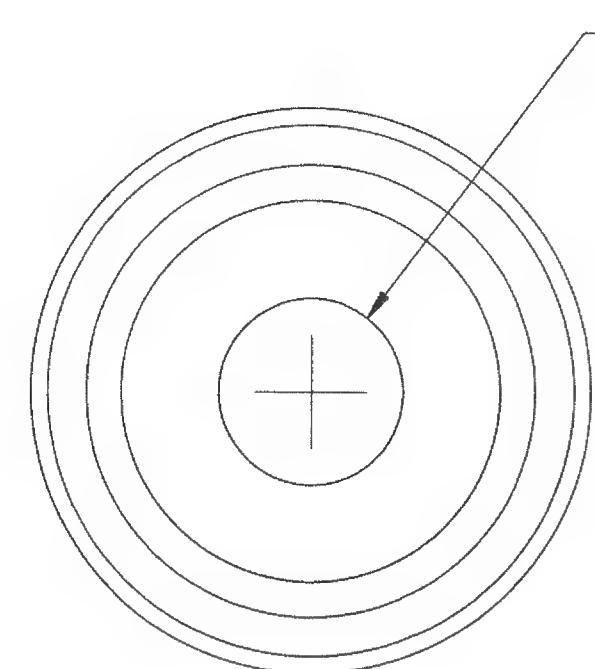
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644.4118  
WASHER, NYLON

ORIGINAL DATE (MO-DA-YR)	08-01-05	APICAL INDUSTRIES
DRAWN BY	CHECKER	
D.PARROTT	S.JOSEPH	
DRAWING APPROVAL		
S.JOSEPH 08-29-05		
CONTRACT NO.		
		PIVOT STEP ASSY
UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN INCHES TOLERANCES ARE: 2 PLACE DECIMALS $\pm .03$ 3 PLACE DECIMALS $\pm .010$ ANGLES $\pm .5^\circ$		
SIZE	CAGE CODE	DWG. NO.
B	07MZ6	644.4100
SCALE	NONE	REV. F
		SHEET 10 OF 16

1 2 3 4 5 6 7 8  
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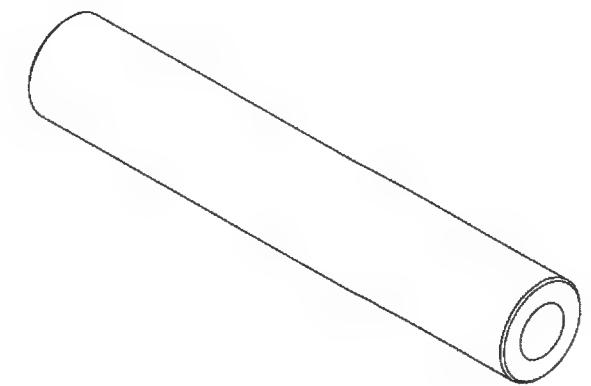
644.4119  
SPACER, FWD STOP

ORIGINAL DATE (MO-DA-YR)	08-01-05	APICAL INDUSTRIES
DRAWN BY	CHECKER	2608 TEMPLE HEIGHTS DR.
D.PAROTTI	S.JOSEPH	OCEANSIDE, CA. 92056-3512 (760)724-5300
DRAWING APPROVAL	S.JOSEPH 08-29-05	
CONTRACT NO.		
UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN INCHES TOLERANCES ARE: 2 PLACE DECIMALS $\pm .03$ 3 PLACE DECIMALS $\pm .010$ ANGLES $\pm 5^\circ$		PIVOT STEP ASSY
SIZE	CAGE CODE	DWG. NO.
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REV.		F
SCALE	NONE	11 OF 16

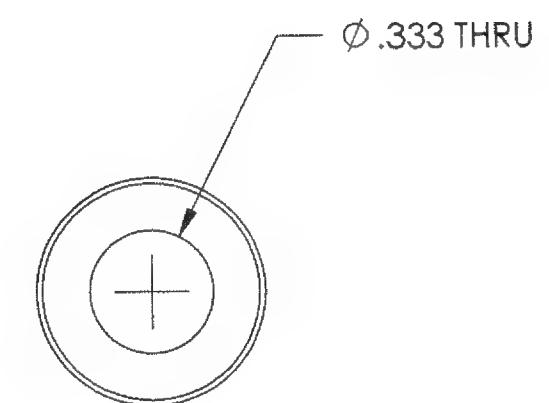
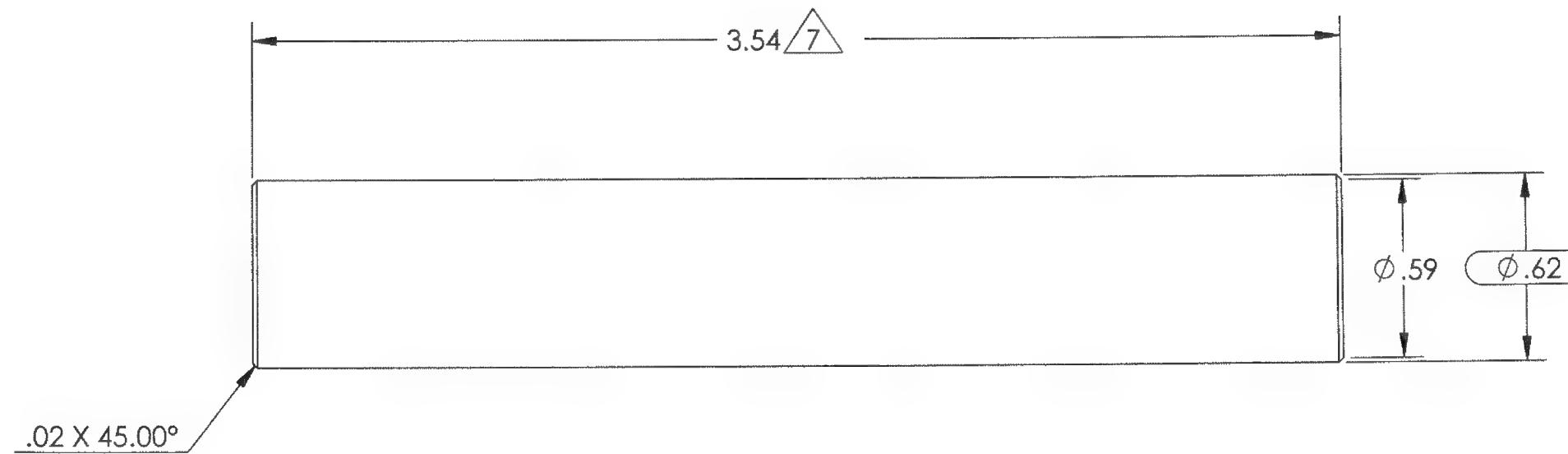
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644.4120  
SPACER, CROSS-TUBE

D

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D.PARROTT	S.JOSEPH	OCEANSIDE, CA. 92056-3512 (760)724-5300
DRAWING APPROVAL	S.JOSEPH 08-29-05	PIVOT STEP ASSY
CONTRACT No.		
UNLESS OTHERWISE SPECIFIED		
DIMENSIONS ARE IN INCHES		
TOLERANCES ARE:		
2 PLACE DECIMALS $\pm .03$		
3 PLACE DECIMALS $\pm .010$		
ANGLES $\pm .5^\circ$		
SIZE	CAGE CODE	DWG. NO.
B	07MZ6	644.4100
REV.		F
SCALE	NONE	SHEET 12 OF 16

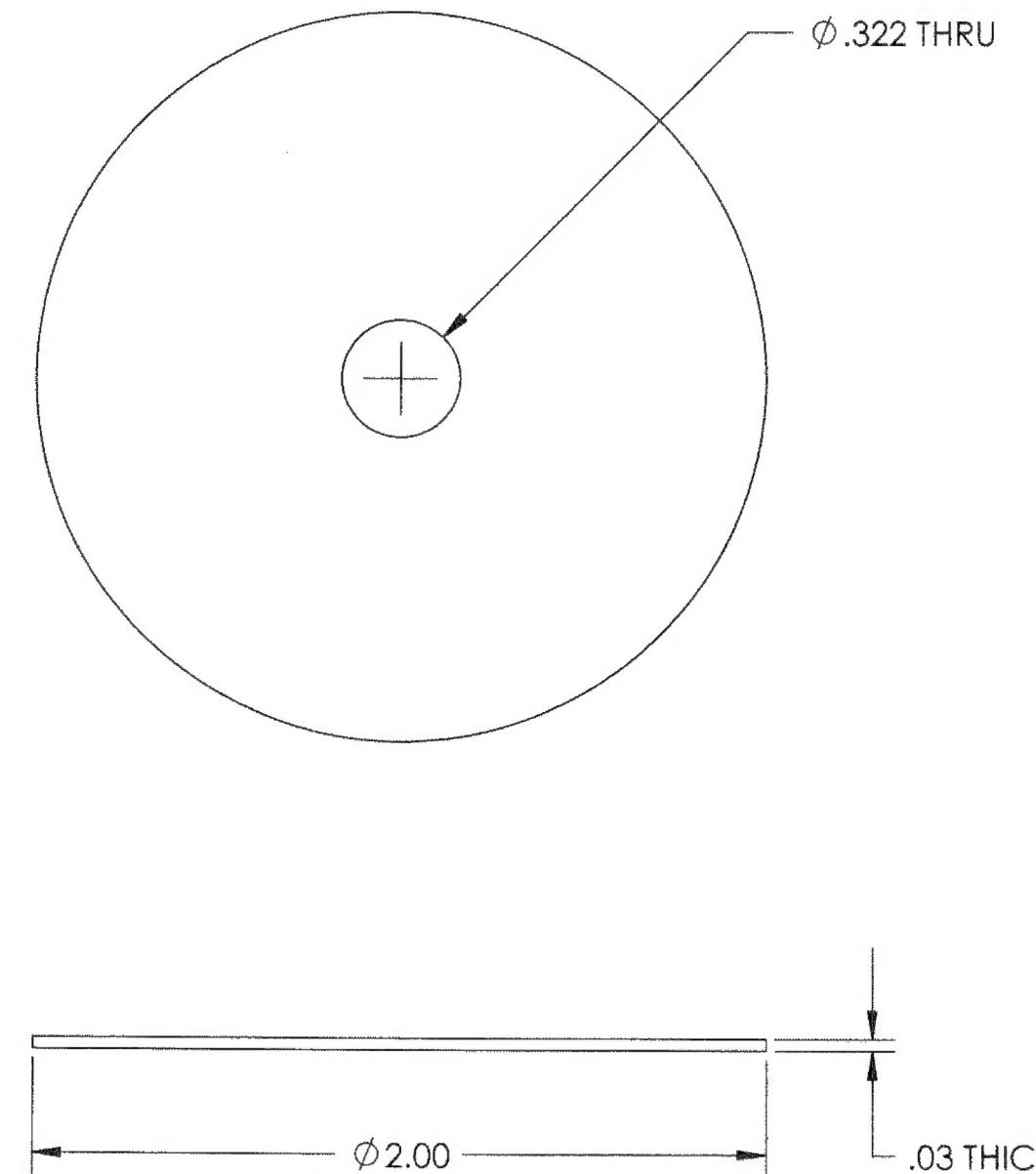
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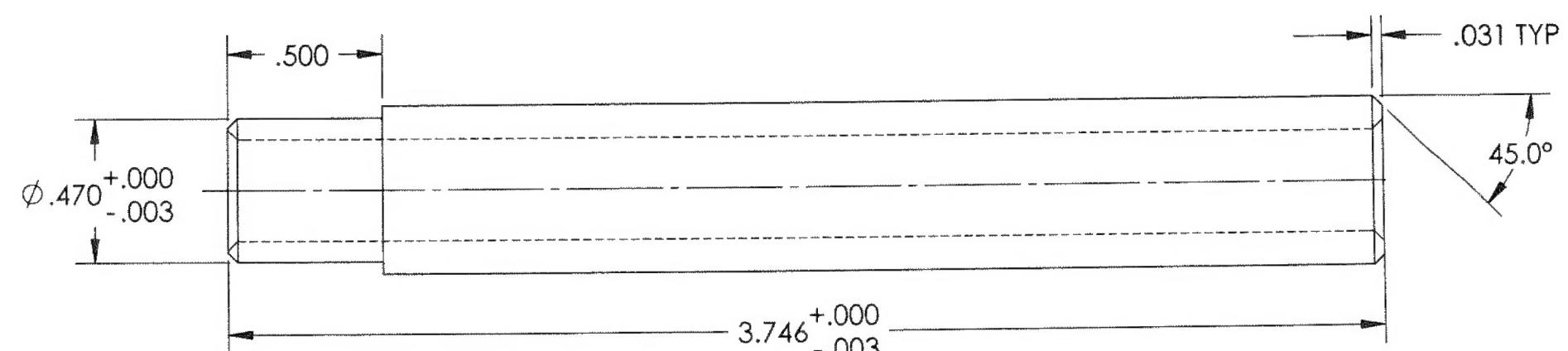
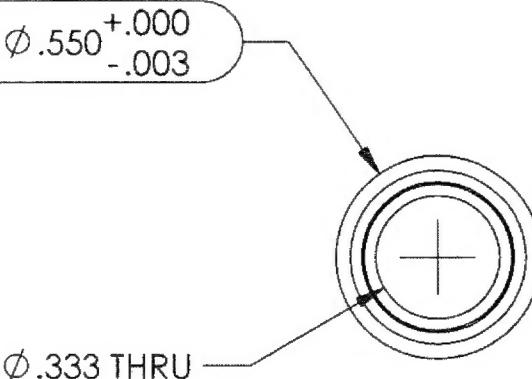
644.4121  
WASHER, NYLON

ORIGINAL DATE (MO-DA-YR)	08-01-05
DRAWN BY D.PAROTTI	CHECKER S.JOSEPH
DRAWING APPROVAL S.JOSEPH 08-29-05	
CONTRACT NO.	
UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN INCHES TOLERANCES ARE: 2 PLACE DECIMALS $\pm .03$ 3 PLACE DECIMALS $\pm .010$ ANGLES $\pm 5^\circ$	

APICAL INDUSTRIES  
2608 TEMPLE HEIGHTS DR.  
OCEANSIDE, CA. 92056-3512 (760)724-5300  
PIVOT STEP ASSY  
SIZE CAGE CODE DWG. NO. 644.4100 REV. F  
B 07M26  
SCALE NONE SHEET 13 OF 16

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644.4122

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DRAWING APPROVAL	S.JOSEPH 08-29-05	PIVOT STEP ASSY
CONTRACT No.		
UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN INCHES TOLERANCES ARE: 2 PLACE DECIMALS ±.03 3 PLACE DECIMALS ±.010 ANGLES ± .5°	SIZE B	CAGE CODE 07MZ6
	DWG. NO. 644.4100	REV. F
SCALE: NONE		SHEET 14 OF 16

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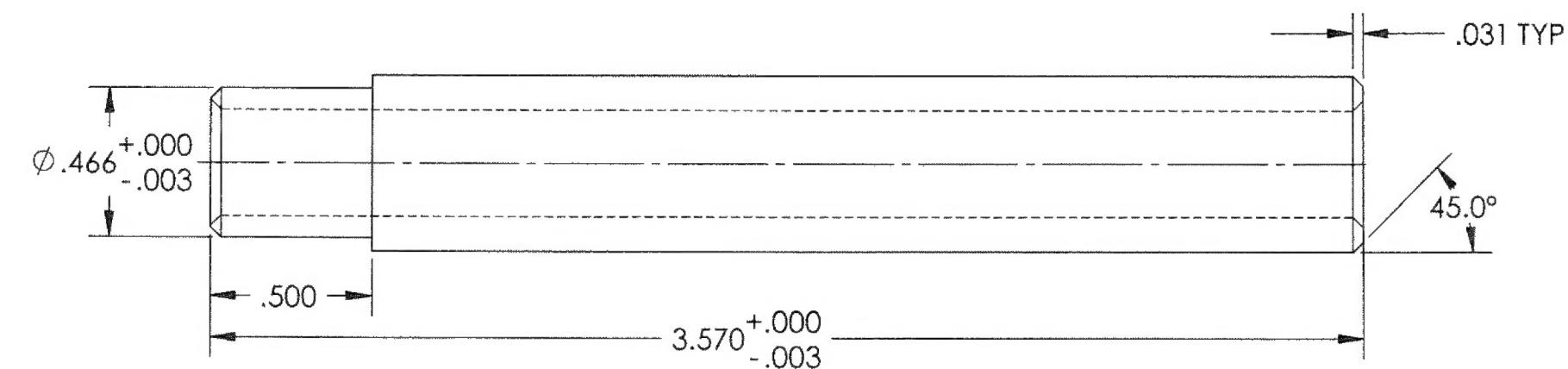
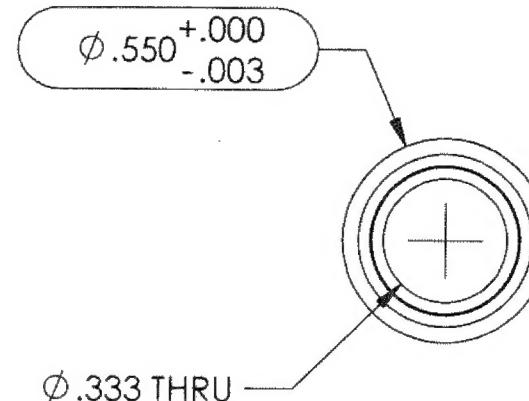
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644.4123

ORIGINAL DATE (DA-MO-YR)	08-01-05		
DRAWN BY	CHECKER		
D.PARROTT	S.JOSEPH		
DRAWING APPROVAL			
S.JOSEPH 08-29-05			
CONTRACT No.			
UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN INCHES TOLERANCES ARE: 2 PLACE DECIMALS ±.03 3 PLACE DECIMALS ±.010 ANGLES ± 5°			
SIZE	CAGE CODE	DWG. NO.	REV.
B	07M26	644.4100	F
SCALE: NONE	SHEET 15 OF 16		

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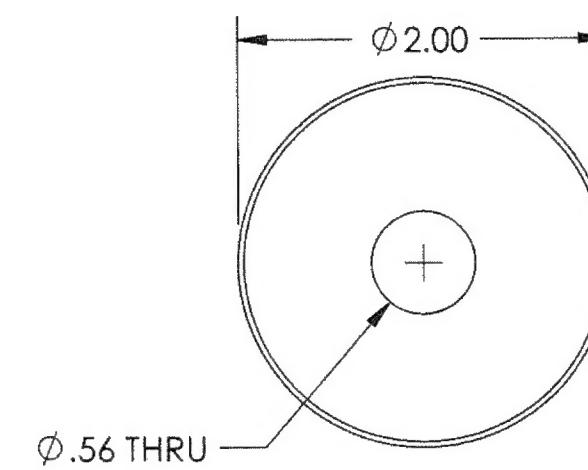
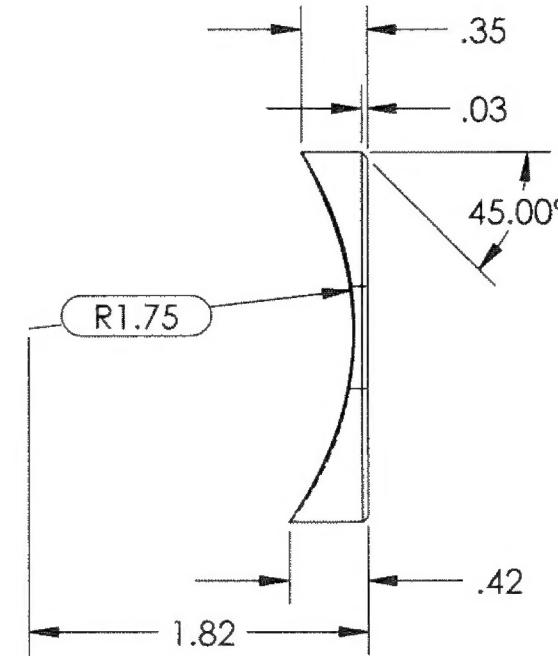
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644.4124

ORIGINAL DATE (DA-MO-YR)	08-01-05	APICAL INDUSTRIES
DRAWN BY D.PARROTT	CHECKER S.JOSEPH	2608 TEMPLE HEIGHTS DR, OCEANSIDE, CA. 92056-3512 (760)724-5300
DRAWING APPROVAL S.JOSEPH 08-29-05		PIVOT STEP ASSY
CONTRACT No.		
UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN INCHES TOLERANCES ARE: 2 PLACE DECIMALS $\pm .03$ 3 PLACE DECIMALS $\pm .010$ ANGLES $\pm 5^\circ$	SIZE B	CAGE CODE 07MZ6
	DWG. NO.	644.4100
	REV.	F
SCALE : NONE		SHEET 16 OF 16